

DT 8731



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2666-1

Job Sheet 208528



Part No: D2666-1

Job Qty: 12 pcs

Part Name: Saddle, LH, Fwd, Aft, In



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/23/20

Job Tracking No:

Due Date: 4/20/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	12 pcs	4/20/20	4/20/20	0.00	10.97	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 20/04/16
							HAAS - 4		
110	Conventional Mill - 1 - B4B	12 pcs	4/20/20	4/20/20	0.00	13.48	Conventional Mill - 1 - B4B		SBL 20/04/16
							Conventional Mill - 2 - B4B		
120	QC 2	12 pcs	4/20/20	4/20/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



Container No: S270610



Part: D2666-1

Job No: 208528

Serial No/Batch: S270610

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/15/20

Plex 3/23/20 11:21 AM Dart.lajeunesse.marie

					QC 2 - 57	SBL 20/04/16
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 86	
130 QC 8	12 pcs	4/20/20	0.00	0.00	QC 8 - 12	mk 20/04/17
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
140 Handfinish - 1-1 Chemical-B4B	12 pcs	4/20/20	0.00	0.62	Handfinish - 1 - 1 - B4B	BEB 20-04-17
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Plex 3/23/20 11:21 AM Dart.lajeunesse.marie	

				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	Powdercoat - 1 White Gl(A)- B4B	12 pcs	4/20/20	0.00 0.53	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
160	QC 3	12 pcs	4/20/20	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43
					QC 3 - 24
					QC 3 - 61
					QC 3 - 81
					QC 3 - 82
					QC 3 - 87
170	Packaging 3-1 - Stock - B4B	12 pcs	4/20/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B

28 04-17

DAS 15 9-89

DAS 28 9-89

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
180 QC 21 - SA	12 pcs	4/20/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-55
Part Op 100 - HAAS CNC Vertical Machine - Program batch number. Descriptions: 110 - Manufacture as per dwg - Machine Keyway and inspect per attached dimension sheet 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum) - START TIME: _____ 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release					
APR 20 2020					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6101-001	Saddle Billet	12 pcs (1 ea)	100-HAAS 4 Axis	S235965	(x 12)
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	D6101-001	12	32	0	
Part Specifications					
Specifications could not be found.					

Plex 3/23/20 11:21 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 208528
Description: 206 Saddle, Inboard, Left side		Part Number: D2666-1
Inspection Dwg: D2666	Rev: D	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.123	0.123	0.123	0.122	0.121
B	0.100	0.140		0.130	0.130	0.130	0.130	0.130
C	2.470	2.510		2.494	2.494	2.494	2.495	2.495
D	0.100	0.180		0.135	0.135	0.135	0.135	0.135
E	0.210	0.230		0.223	0.223	0.223	0.223	0.221
F	1.313	1.343		1.325	1.325	1.325	1.325	1.325
G	0.240	0.260		0.251	0.252	0.251	0.251	0.252
H	0.615	0.685		0.655	0.655	0.655	0.655	0.655
I	1.125	1.145		1.135	1.135	1.135	1.135	1.135
J	0.990	1.010		1.003	1.003	1.003	1.003	1.003
K	0.235	0.240		0.238	0.238	0.238	0.238	0.238
L	0.510	0.515		0.511	0.511	0.511	0.511	0.511
M	0.100	0.120		0.110	0.110	0.110	0.110	0.110
N	1.565	1.585		1.575	1.575	1.575	1.575	1.575
O	5.990	6.010		6.000	6.000	6.002	6.002	6.002
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.490	0.510		0.500	0.500	0.500	0.500	0.499
S	0.312	0.318		0.313	0.313	0.313	0.313	0.313
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362
V	0.315	0.322		0.316	0.316	0.316	0.316	0.316
W	0.540	0.560		0.547	0.547	0.547	0.547	0.546
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679
Y	0.256	0.262		0.258	0.258	0.258	0.258	0.258
Z	0.178	0.198		0.188	0.188	0.188	0.188	0.188
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: DTD/SBL	Date: 20/04/16
Audited by: GMR	Date: 20/04/17
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	
H	12.03.08	Dimension S and Y revised	KJ	AM

DART AEROSPACE LTD		Work Order: 205528
Description: 206 Saddle, Inboard, Left side		Part Number: D2666-1
Inspection Dwg: D2666	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6	7	8	9	10
A	0.100	0.140		0.122	0.121	0.122	0.123	0.123
B	0.100	0.140		0.130	0.130	0.130	0.129	0.131
C	2.470	2.510		2.495	2.495	2.495	2.493	2.495
D	0.100	0.180		0.135	0.135	0.135	0.135	0.135
E	0.210	0.230		0.221	0.221	0.222	0.222	0.222
F	1.313	1.343		1.325	1.323	1.323	1.325	1.324
G	0.240	0.260		0.252	0.252	0.252	0.252	0.252
H	0.615	0.685		0.655	0.655	0.658	0.655	0.657
I	1.125	1.145		1.135	1.135	1.135	1.135	1.135
J	0.990	1.010		1.003	1.003	1.003	1.003	1.003
K	0.235	0.240		0.238	0.238	0.237	0.238	0.238
L	0.510	0.515		0.511	0.511	0.511	0.511	0.511
M	0.100	0.120		0.110	0.110	0.110	0.110	0.110
N	1.565	1.585		1.575	1.575	1.575	1.575	1.575
O	5.990	6.010		6.002	6.002	6.002	6.002	6.002
P	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Q	2.495	2.505		2.500	2.500	2.500	2.500	2.500
R	0.490	0.510		0.499	0.500	0.499	0.500	0.499
S	0.312	0.318		0.312	0.312	0.312	0.312	0.312
T	2.495	2.505		2.500	2.500	2.500	2.500	2.500
U	1.357	1.367		1.362	1.362	1.362	1.362	1.362
V	0.315	0.322		0.316	0.316	0.316	0.316	0.316
W	0.540	0.560		0.546	0.548	0.548	0.548	0.548
X	1.674	1.684		1.679	1.679	1.679	1.679	1.679
Y	0.256	0.262		0.258	0.258	0.258	0.258	0.258
Z	0.178	0.198		0.188	0.188	0.188	0.188	0.188
AA								
AB								
AC								
AD								
AE								

Accept/Reject

Measured by: DJD / SBL	Date: 20/04/16
Audited by: MX	Date: 20/04/17
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	
H	12.03.08	Dimension S and Y revised	KJ	AM

DART AEROSPACE LTD				Work Order: 28528	
Description: 206 Saddle, Inboard, Left side				Part Number: D2666-1	
Inspection Dwg: D2666 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
A	0.100	0.140		122	123			
B	0.100	0.140		129	130			
C	2.470	2.510		2,495	2,495			
D	0.100	0.180		135	135			
E	0.210	0.230		222	222			
F	1.313	1.343		1,325	1,325			
G	0.240	0.260		252	252			
H	0.615	0.685		655	655			
I	1.125	1.145		1,135	1,135			
J	0.990	1.010		1,003	1,003			
K	0.235	0.240		238	238			
L	0.510	0.515		511	511			
M	0.100	0.120		110	110			
N	1.565	1.585		1,575	1,575			
O	5.990	6.010		6,002	6,002			
P	1.245	1.255		1,250	1,250			
Q	2.495	2.505		2,500	2,500			
R	0.490	0.510		499	499			
S	0.312	0.318		312	312			
T	2.495	2.505		2,500	2,500			
U	1.357	1.367		1,362	1,362			
V	0.315	0.322		316	316			
W	0.540	0.560		547	548			
X	1.674	1.684		1,679	1,679			
Y	0.256	0.262		258	258			
Z	0.178	0.198		188	188			
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: SBL	Date: 20/04/16
Audited by: [Signature]	Date: 20/04/17
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	
H	12.03.08	Dimension S and Y revised	KJ	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					